

Date: Tuesday, 28/11/2006 10:09:48 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: D26652			
Job Number	: 29719		Part Number	: D26652			
Estimate Number	: 10804		Drawing Number	: RTN 531			
P.O. Number	: N/A		Project Number	: N/A			
This Issue	: 28/11/2006	S.O. No.	: N/A		Drawing Revision	: N/A	
Prsh't Rev.	: NC		Material	: N/A			
F'rst Issue	: N/A		Due Date	: 05/12/2006			
Previous Run	: 29718		Qty:	1	Um:	Each	
Written By	:						
Checked & Approved By	:						
Comment	:						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	QC5	INSPECT WORK TO CURRENT STEP
		 Comment: INSPECT RTN 531
2.0	D26652	Saddle, RH, Fwd,Aft, Out
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Saddle, RH, Aft, Out ORIGINAL B/N 23921
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 ID & STK USING NEW B/N
4.0	QC21	FINAL INSPECTION/W/O RELEASE
		 Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Work 01/19

535

DART AEROSPACE LTD.	Work Order:	23921
Description: 206 Saddle, Outboard, Right Side	Part Number:	D2665-2
Drawing: D2665 Rev B	Qty:	12

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required RF 02/09/16</i>	A	05/08/09	12
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length (D6101-003) RF 02/09/16 Batch No: 22241	J	05/08/09	12
3	HAAS	Program batch number.	NT		12
4	QC	Inspect part number and batch number are programmed correctly. 23921	EN	05/08/09	12
5	HAAS	Fixture W/O No. NA Fixture Inspection last completed on _____ by _____	EN	05/08/09	12
8	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	J	05/08/09	12
9	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	J	05/08/09	12
10	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	J	05/08/09	12
11	LAGUN	Machine Keyway and inspect per attached dimension sheet	J	05/08/09	12
12	METAL	Deburr	EN	05/08/09	12
13	HAAS	Inspect Level 1	J	05/08/09	12
14	QC	Inspect Level 8	RG	05.09.30	12
15	METAL	Acid etch and Alodine as per QSI 005 4.1	SAD	05/11/09	12
16	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	M	05/12/09	12
17	QC	Inspect Level 3	C	05/12/09	12
18	STORES	Pack in foam, identify and stock.	Luc 363	05/12/09	12
19	EXPEDITING	Close Work Order Job Cost / Part <i>Sub 05/12/09 (12)</i>	R	05/12/09	12

Rev	Date	Change	Revised By	Approved
A	97.07.24			
B	98.09.02	Inspection Levels, Added Powder Coat	KS	
C	00.11.01	Removed P/O for Powder Coat – in house process	EC	

RELEASED

EE DEC 18 2009

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/09/27	#11	SKID Tube Ridge slot milled 0.005" than to spec. 0.030" instead 0.035" 0.040"						
		Steel Attached front						

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.120	.126	.126		
B	0.100	0.140		.125	.122	.124	.125		
C	0.100	0.140		.125	.125	.126	.126		
D	0.210	0.230		.218	.217	.218	.218		
E	1.245	1.255		1.250	1.250	1.251	1.250		
F	1.245	1.255		1.249	1.250	1.251	1.249		
G	5.990	6.010		6.002	6.003	6.002	6.003		
H	0.510	0.515		.511	.511	.511	.511		
I	1.674	1.684		1.680	1.680	1.680	1.680		
J	2.495	2.505		2.498	2.499	2.499	2.500		
K	0.257	0.262	DT8683					✓	
L	0.312	0.317	DT8686		✓	✓		✓	
M	0.235	0.240		.235	0.240	0.240	0.240		
N	0.100	0.140		.106	.108	.109	.109		
O	0.540	0.560		.555	.551	.550	.551		
P	0.490	0.510		.506	.504	.502	.502		
Q	3.609	3.619		3.612	3.612	3.612	3.612		
R	2.470	2.510		2.501	2.498	2.499	2.498		
S	0.240	0.270		.240	.241	.246	.246		
T	0.100	0.180		.140	.140	.140	.140		
U	0.313	0.318	DT8686					✓	
V	1.125	1.145		1.138	1.138	1.136	1.136		
W	1.565	1.585		1.576	1.576	1.575	1.574		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: *JF*
Date: *05/09/16*

Audited by: *CD*
Date: *05/10/16*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF <i>RF</i>	<i>##</i>

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.127	0.123	0.123	0.122		
B	0.100	0.140		.125	0.129	0.121	0.123		
C	0.100	0.140		.125	0.126	0.126	0.125		
D	0.210	0.230		.219	0.214	0.219	0.221		
E	1.245	1.255		1.250	1.246	1.247	1.249		
F	1.245	1.255		1.250	1.247	1.247	1.249		
G	5.990	6.010		6.002	6.002	6.003	6.002		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.674	1.684		1.681	1.675	1.676	1.676		
J	2.495	2.505		2.499	2.497	2.497	2.494		
K	0.257	0.262	DT8683						
L	0.312	0.317	DT8686						
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		0.106	0.107	0.107	0.107		
O	0.540	0.560		.549	0.547	0.548	0.546		
P	0.490	0.510		.501	0.499	0.498	0.497		
Q	3.609	3.619		3.612	3.609	3.610	3.609		
R	2.470	2.510		2.505	2.500	2.499	2.498		
S	0.240	0.270		.246	0.242	0.248	0.247		
T	0.100	0.180		.140	0.134	0.141	0.133		
U	0.313	0.318	DT8686						
V	1.125	1.145		1.136	1.137	1.136	1.138		
W	1.565	1.585		1.576	1.575	1.574	1.577		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	EP	Audited by:	gm
Date:	05/09/27	Date:	05/09/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF RF	#

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Outboard, Right side	Part Number:	D2665-2
Inspection Dwg: D2665 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		0.120	0.120	0.121	0.120		
B	0.100	0.140		0.122	0.123	0.121	0.121		
C	0.100	0.140		0.123	0.122	0.122	0.123		
D	0.210	0.230		0.218	0.220	0.223	0.221		
E	1.245	1.255		1.246	1.248	1.248	1.248		
F	1.245	1.255		1.246	1.248	1.248	1.248		
G	5.990	6.010		6.001	6.001	6.001	6.003		
H	0.510	0.515		0.511	0.511	0.511	0.511		
I	1.674	1.684		1.676	1.677	1.677	1.678		
J	2.495	2.505		2.497	2.497	2.497	2.497		
K	0.257	0.262	DT8683	—	—	—	—		
L	0.312	0.317	DT8686	—	—	—	—		
M	0.235	0.240		0.240	0.240	0.240	0.240		
N	0.100	0.140		0.107	0.106	0.108	0.108		
O	0.540	0.560		0.544	0.545	0.545	0.545		
P	0.490	0.510		0.498	0.501	0.498	0.499		
Q	3.609	3.619		3.610	3.612	3.609	3.610		
R	2.470	2.510		2.498	2.499	2.499	2.500		
S	0.240	0.270		0.245	0.243	0.243	0.244		
T	0.100	0.180		0.133	0.139	0.139	0.138		
U	0.313	0.318	DT8686	—	—	—	—		
V	1.125	1.145		1.138	1.140	1.141	1.140		
W	1.565	1.585		1.576	1.578	1.580	1.580		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>CP</i>
Date:	05/09/27

Audited by:	<i>DR</i>
Date:	05/09/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DS1 9095, DS1 9102 & DS1 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF <i>RF</i>	<i>#</i>

DART

DESIGN

DRAWN BY

CHECKED

APPROVED

DATE

97.07.11

KE

DART AEROSPACE USA, INC.

FAIRCHILD INTERNATIONAL AIRPORT, WA

REV. B

SHEET 1 OF 1

DRAWING NO.

D2665

SCALE

2:5

TITLE

SADDLE FWD OUTSIDE HIGH

000000000

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 02, 2005
01:38 pm

Work Order No : 0023921
Project Name : D2665-2 Department Code:
Project For : WK535 Burden Flags : NNNNNNNN
Work Order Type : Main WO Status : Open
Main WO Number : Invoice State : Not Invoiced
House Part Number : D2665-2 Invoice Date :
Description : Saddle, RH, Fwd,Aft, Out Invoice Number :
Manufactured : Yes Invoice Amount : 0.00
Amount Req'd : 12
Amount Done : 0 Order Entry No :
Start Date : 08-02-05 OE Value : 0.00
Est Finish Date : 08-31-05 Est Margin : 0.000%
Act Finish Date : Actual Margin : 0.000%
Drawings Reqd : No
Ok for Approval :
Approval Rec'd : \$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00

ATTN: Roberto @ 613-632-4443

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/09/27	II	SEND Tube Endge ±0.3 milled less than to th.a - 0.230 instead of 0.235 0.240	#	ACCEPTABLE Deviation	# 05.09.27	# 05.09.27	# 05.09.27	# 05.09.27

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 05/12/20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Monday, 11/14/2005 2:43:12 PM
 User: Linda Lacelle

Process Sheet

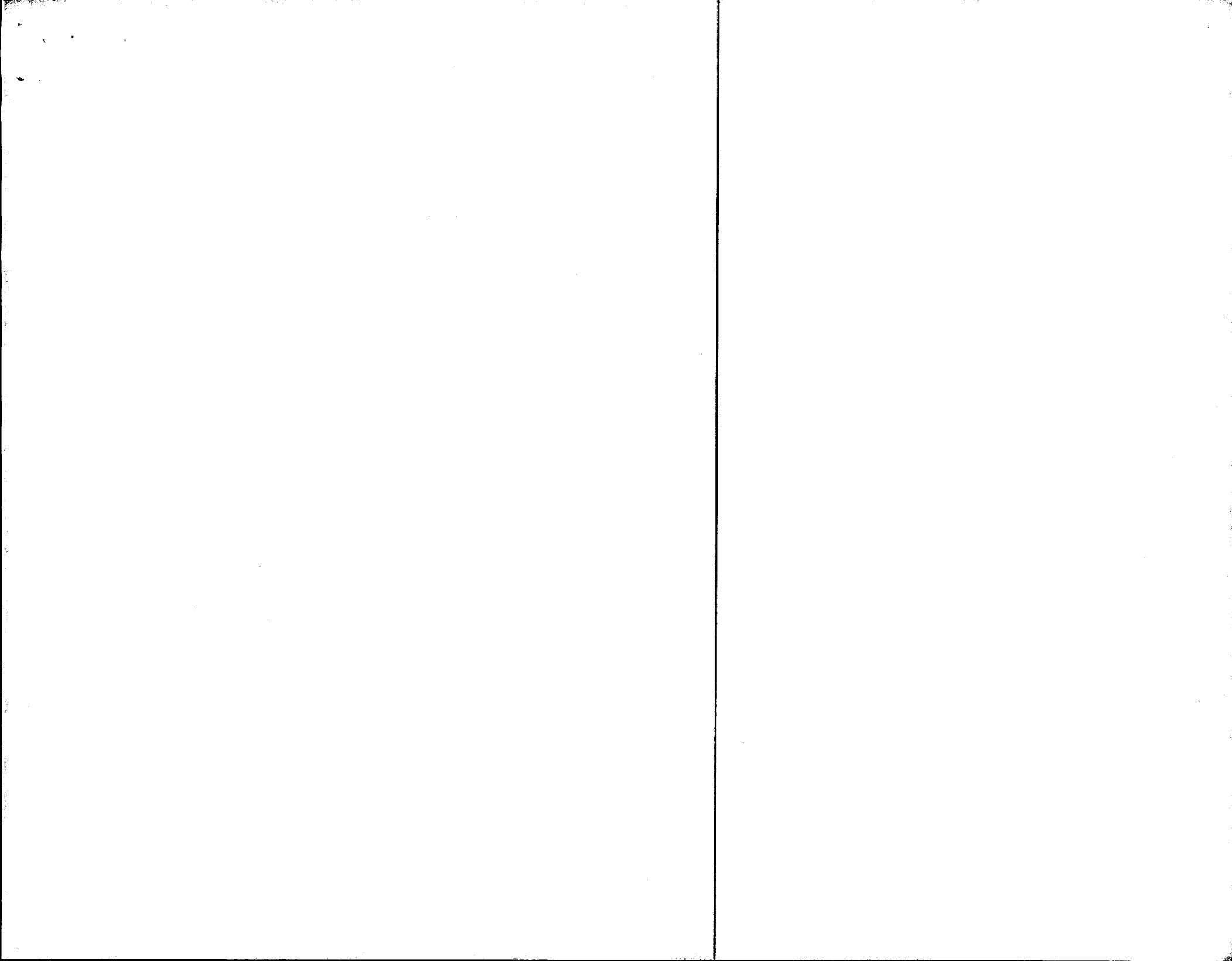
Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE, OUTBOARD, RH, 206		
Job Number	: 23921			Part Number	: D26652	
Estimate Number	: 10523			Drawing Number	: D2665 REV. B	
P.O. Number	:			Project Number	:	
This Issue	: 11/14/2005		S.O. No. :	Drawing Revision	: B	
Prsh Rev.	: NC			Material	:	
First Issue	: / /		Type : MACHINED PARTS	Due Date	: 11/30/2005	
Previous Run	: 24499			Qty:	12	
Written By	:			Um:	Each	
Checked & Approved By	:					
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house process EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
Comment: HAAS CNC VERTICAL MACHINING #1 1- Program batch number 2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet 5- Deburr			
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
5.0	QC8	SECOND CHECK	
Comment: SECOND CHECK			



Date: Monday, 11/14/2005 2:43:12 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 23921

Part Number: D26652

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<p>Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1</p>		
<p>Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3</p>		
7.0	POWDER COATING	POWDER COATING
<p>Comment: INSPECT POWDER COAT Identify and Stock Location: _____</p>		
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
<p>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____</p>		
9.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: DOCUMENT CONTROL Inspection Level 21</p>		
<p>Job Completion</p>		

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
10:44 am

Work Order No	:	0023921	Department Code:
Project Name	:	D2665-2 ✓	Burden Flags : NNNNNNN
Project For	:	WK535	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D2665-2	Invoice Number :
Description	:	Saddle, RH, Fwd,Aft, Out	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	12	Order Entry No :
Amount Done	:	0	OE Value : 0.00
Start Date	:	08-02-05	Est Margin : 0.000%
Est Finish Date	:	08-31-05	Actual Margin : 0.000%
Act Finish Date	:		
Drawings Reqd	:	No	
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	23.50	100.00		
Production Cost	: 0.00	482.10	100.00	0.00	482.10
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	24.00	100.00		
CNC	: 0.00	111.48	100.00	0.00	111.48
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
Burden	: 0.00	0.00	0.00		
Total Cost	: 0.00	593.58	100.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	593.58			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	(-593.58)

*WHS 2/b
in
11-14*